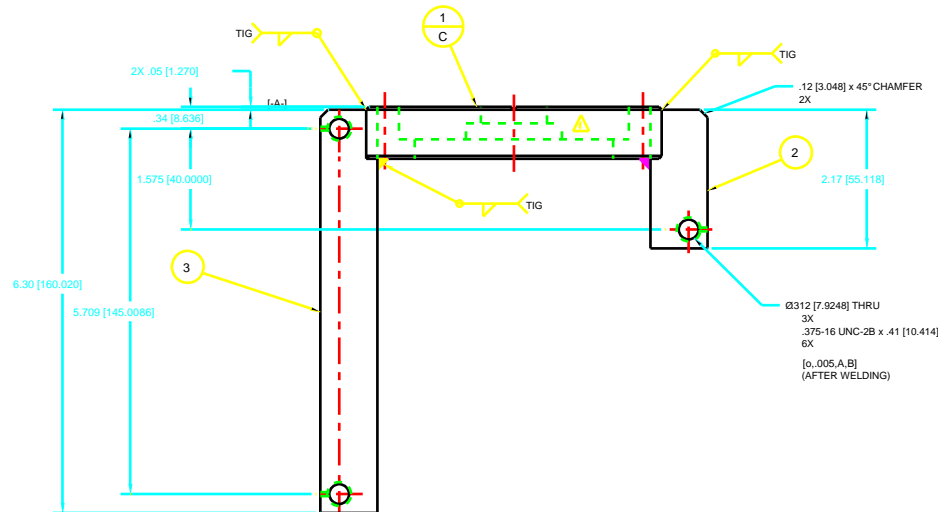
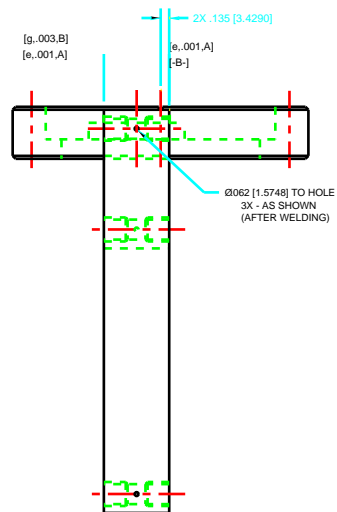
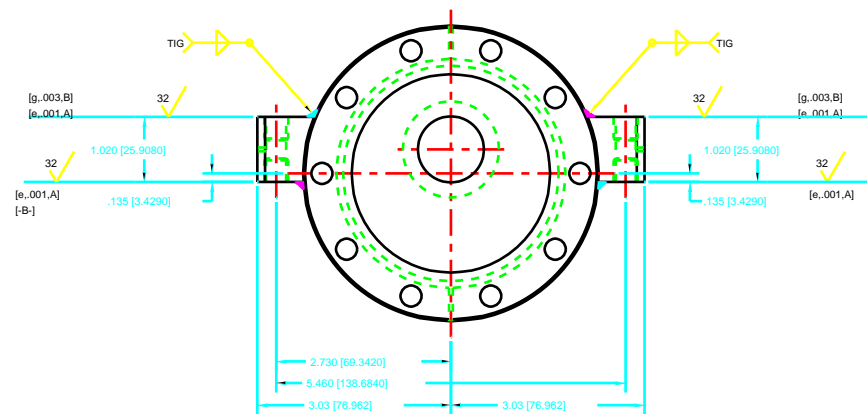




(D)	PLOT SCALE: 1=1	DWG. SCALE: 1
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- NOTES:
- THIS IS A ULTRA-HIGH VACUUM WELDMENT (UHV)
 - WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
 - PRIOR TO WELDING REMOVE ALL EXCESS LUBRICANTS. WELDS SHALL BE GAS TUNGSTEN ARC (GTAW) OR TUNGSTEN INERT GAS (TIG) ON VACUUM SIDE OF JOINTS.
 - ALL DIMENSIONS IN [] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.
 - MACHINING TO FINAL DIMENSIONS AFTER WELDING.



		3	LONG BAR		SST 304		1
		2	SHORT BAR		SST 304		1
A15569	1	P4105091505-210108-00		L5 FLANGE, MODIFIED (OUTER PART)		SST 304	1
LOG	ITEM	DWG/PART NUMBER		NOMENCLATURE OR DESCRIPTION		MATERIAL / SPEC	QTY
PARTS LIST							
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES: DECIMALS ANGULAR X .015 XX .010 XXX .005				LOG NUMBER A1558901			
SURFACE ROUGHNESS 63				THIS DRAWING IS THE PROPERTY OF  ARGONNE NATIONAL LABORATORY			
DRAWN BY: R. KRAKORA		DATE: 12/93	CHECKED BY/ENGINEER: D. SHU		DATE: 2/94	TITLE: ADVANCED PHOTON SOURCE L5 APS UNDULATOR WHITE BEAM H & V SLITS LOWER SUPPORT WELDMENT	
DESIGNED BY: D. SHU		DATE: 12/93	PROJECT NO.:				
RESPONSIBLE ENGINEER: D. SHU		DATE: 2/94	APPROVED/RELEASED: 				
MATERIAL: SEE B.O.M.							
DO NOT SCALE DRAWING							
SCALE: 1:1		SIZE: D		DRAWING NUMBER: P4105091505-220200-01			
SHEET: 1 of 1							

1	PICTORIAL CORRECTION FRONT, SIDE & TOP VIEW	RAF	CB	7/96
BYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				